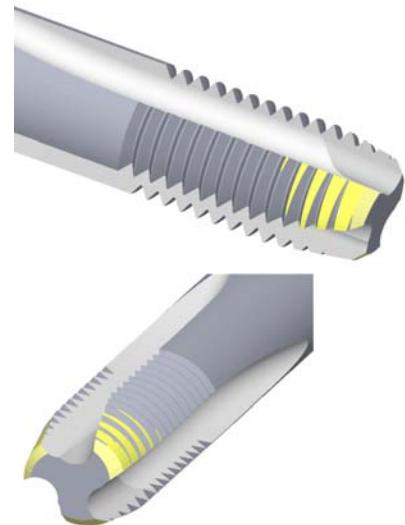


Tap M6 Z3

A10-020

In the manufacturing cycle is included the dressing cycle for the conventional wheel for fluting and threadfinishing. An inverse calculation for the flutewheelshape based on graphical input of the fluteform is available.



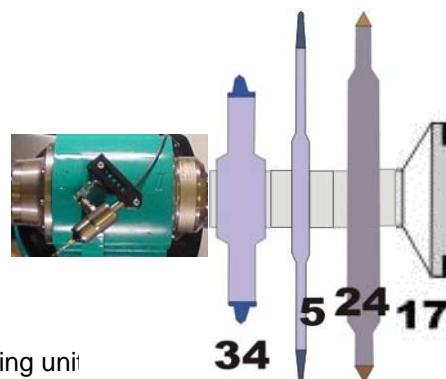
1. Cycletime for Production

Tool specifications								
	M6, Length 23 mm, flutelength 27, Helix 0°							
Material HSS								
Operations								
Flute 1	1000	180	200	200	1400	1400	100	100
Power [kW]	4	2	1	1	1	1	1	1
Cutting feed [m/s]	46	40	32	32	48	48	24	24
Used wheels								
Grinding time [s]	92	56	77	77	89	86	28	28
Total cycle time	8 Min 54							

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø175 DXF A120
17 Ø125 12A2 B126
5 Ø150 14E1 A120
24 Ø125 14E1 A220



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, dressing unit
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP,20.5.08

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TECHNOLOGY
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